

# Work Order ID 47755

June 26, 2009 12:27:21 PM

Page 1

Item ID: D119-646-213  
Revision ID: Prelim  
Item Name: Float Skidtube Installation

Accept

Setup Start

Stop

Start Date: 15/07/2009 Start Qty: 1.00

Required Date: 03/08/2009 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID      Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

SEE ATTACHED wlo

100

0.00



DC

Memo

0.00

Document Control

PRELIMINARY ISSUE

QC 21 - FOR ENG USE ONLY  
09/09/28/09

mf  
09-07-09

Date: Tuesday, 05/05/2009 4:09:27 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FLOAT SKIDTUBE INSTALLATION
<b>Job Number</b> : 47755	
<b>Estimate Number</b> : 13923	
<b>P.O. Number</b> :	<b>Part Number</b> : D119646213
<b>This Issue</b> : 05/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : PRELIM
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 12/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>MF 09-05-08.</u>	
<b>Comment</b> : Est Rev:A 09-05-05 new issue EC verified by:DD	

## Additional Product

PRELIMINARY ISSUE

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D119-646-311 CHG001

N/A

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D119646243	Replacement Float Skidtube w/ Training W
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Replacement Float Skidtube w/ Training W

batch: 47742

CP 05/06/02

4.0	D119646311	Ground Handling
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ground Handling

batch: 47812

9/6/12

SP

5.0	D38831	Saddle, Outboard, LH
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle, Outboard, LH

batch: R 47826

Y2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 05/05/2009 4:09:27 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE INSTALLATION

Job Number: 47755

Part Number: D119646213

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D38832

Saddle, Outboard, RH



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Saddle, Outboard, RH

batch:

NOT REQ'D  
RH only

7.0

D38841

Saddle, Inboard, LH



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Saddle, Inboard, LH

batch: 347828

2.

8.0

D38842

Saddle, Inboard, RH



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Saddle, Inboard, RH

batch:

NOT REQ'D  
RH only

9.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bushing

batch: B47649

9/6/12

SLP

10.0

AN3C51A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: M112046

9/6/12

SLP

11.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bolt

batch: M11295

9/6/12

SLP

12.0

AN5C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

batch: M110046

MS21250-05006

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE INSTALLATION

Job Number: 47755

Part Number: D119646213

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN960C10L

washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

washer

batch: M111808

9/6/12

SP

14.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

batch: M111916

9/6/12

SP

15.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

batch: M110139

9/6/12

SP

16.0

MS210433

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: M111819

9/6/12

SP

17.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: M111819

9/6/12

SP

18.0

D2712

Set Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Set Screw

batch: B15017

9/6/12

SP

19.0

D36725

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Phenolic Washer

batch: B344679

9/6/12

(12)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE INSTALLATION

Job Number: 47755

Part Number: D119646213

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D36723

Phenolic Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Phenolic Washer

batch: B47023

9/6/2

SP

21.0

D36727

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Phenolic Washer

batch: B35522

9/6/2

SP

22.0

AN3C47A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

BOLT

batch: M106171

9/6/2

SP

23.0

D39041

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

batch: B48374

24.0

AN4C6A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bolt

batch: M111295

9/6/2

SP

25.0

D36723

Phenolic Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Phenolic Washer

batch: B47023

9/6/2

SP

26.0

AN960C416L

WASHER



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

WASHER

batch: M111916

9/6/2

SP



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE INSTALLATION

Job Number: 47755

Part Number: D119646213

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: M111879

9/6/2

SD

28.0

AN960C10L

washer



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

washer

batch: M111808

9/6/2

SD

29.0

MS210433

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch: M111758

M111819

9/6/2

SD

30.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch: B47309

9/6/2

SD

31.0

D34175

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: B44350

9/6/2

SD

32.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

batch: B46752

9/6/2

SD

33.0

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Nut

batch: M111819

9/6/2

(14)

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: FLOAT SKIDTUBE INSTALLATION

Job Number: 47755

Part Number: D119646213

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-646-311

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

N/A for eng's

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

N/A FOR ENG USE ONLY 09/09/28

Job Completion



QC.4.



ENGINEERING  
APPROVAL  
09-07-01

POSITIVE RECALL

EFFECTIVE 09-05-12 AUTH Li

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

mf  
09-07-07